

03203-1

Work Order ID 109418 B 1 0 9 4 1 8

November-21-13 2:22:58 PM

109418

Page 1

Item ID: D3203-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Handle

Start Date: 11/21/13 Start Qty: 12.00 *12*

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 12.00 *12*

Customer:

Reference:

Approvals:	Process Plan: <u>MJS</u>	Date: <u>11-25</u>	Tooling:	Date:	Run	Start	*NR1*
QC:		Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3203	Rev C

100 0.00

100 PURCHASING

Purchasing Memo 0.00

Purchasing Issue P/O: 22191 Possible Supplier: Mill Supply P/N GH-180-C
order (4) per Kit identify for D3203-1 Conformity certificate is required

Cx 13/11/26 (12)

110 0.00

110 Packaging Memo 0.00

Packaging Ensure certificate of conformity is attached

Dx _____ SP
B-11-27

120 0.00

120 QC Memo 0.00

Quality Control QC6- Inspect dimensions to drawing

0.00 SJP
0.00 B-11-28

12 _____

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
		Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
		Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>					
		Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
		Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>					
		Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
		Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
		Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>						
		Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
		Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
		Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
		Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

Work Order ID 109418

November-21-13 2:22:58 PM

109418

Page 2

Item ID: D3203-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Handle

Stop

NS2

Start Date: 11/21/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ST240

0.00

130

Packaging

Packaging

0.00

12X13-11-28

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

DAS

26

9-89

gj/Rm 13/12/02MF
13-11-29

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
Scrap
Use-as-is
Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
Machining
Thermoforming
Large Fab

Crosstube
Small Fab
Finishing
Composite

Water Jet
Prod. Eng. Coor.
Rec/Store/Packaging
Supplier

Engineering
Quality
Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	Bending	General	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric		Grain	Over/Under tolerance	Set-up
	Cracks		Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs		Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing		Misaligned/off center	Positioned Wrong	
	Heat Treat		Mislabeled	Power Loss/Surge	Other
	Inspection Strip in Tube		Misread		
	Marks/Chatter		Off-set		
	Turning Sequence		Out of Calibration		
	Wave/Twist in Tube		Out of Sequence		

Picklist Print

November-21-13 2:22:57 PM

Page 1 / 1

Work Order ID: 109418**Parent Item:** D3203-1**Parent Item Name:** Handle**Start Date:** 11/21/13**Required Date:** 11/21/13**Start Qty:** 12.00**Required Qty:** 12.00**Comments:** IPP Rev:A New Issue 05-11-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
GH180C Handle		Purchased	No			100	Each	0.0000	1	12	<i>DX SP</i>	<i>B-11-27.</i>	

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
Scrap
Use-as-is
Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
Machining
Thermoforming
Large Fab
Crosstube
Small Fab
Finishing
Composite

Water Jet
Prod. Eng. Coor.
Rec/Store/Packaging
Supplier

Engineering
Quality
Other

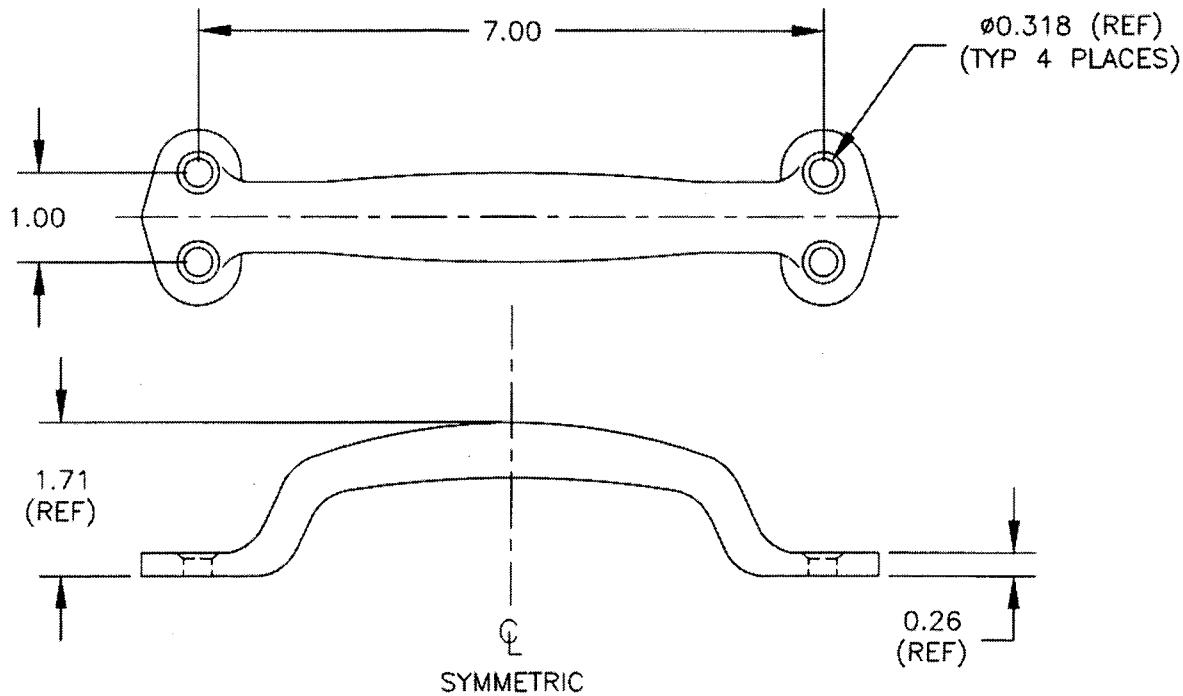
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
		Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced					
		Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up					
		Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure					
		Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld					
		Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled					
		Crushing	Countersink	Misaligned/off center	Positioned Wrong						
		Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other					
		Inspection Strip in Tube	Drawing	Misread							
		Marks/Chatter	Drill Holes	Off-set							
		Turning Sequence	Finish	Out of Calibration							
		Wave/Twist in Tube	Fit/Function	Out of Sequence							

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. C D3203 SHEET 1 OF 1
DATE		TITLE SCALE
04.11.26		HANDLE 1:2
A	03.08.27	NEW ISSUE
B	03.10.16	REDESIGN HANDLE
C	04.11.26	NO MACHINING

RELEASED
05.01.18D3203-1 HANDLE

- 1) PURCHASE FROM MILL SUPPLY, P/N GH-180-C OR 27-526
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1094-811601
13-11-25



MILL SUPPLY, INC.

19801 Miles Rd, Cleveland, OH 44128-4117
Remit To: Po Box 28750, Cleveland, OH 44128-0750

Local (216) 518-5072
Toll-Free (800) 888-5072
Fax (216) 518-2700
Fax-Free (888) 781-2700

292065 INVOICE

CREDIT CARD

11/26/2013 < Ship Date

Customer #

Phone

Ship #

11/17 062123 D

Phone

DARTK6A1K S-48 613-632-9577

B
I
L
L
I
N
G

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY ON K6A1K7

Order Date	Ordered By	P.O. Number	Salesman	Terms	Other Info
11/26/2013	FAXED ORDER	P022191	JUP	NET	
Qty	U/M	Part Number	Description	Unit Cost	Line Total
12 EA	27-526	(GH180C) GRAB HANDLE	35-4-2	7.87	94.44
ORDER COMPLETE					
***** * Stay updated with us on * * Facebook, Twitter & YouTube! * *****					
<i>B-11-27</i>					
*** NEW FOR 2013 - BOX TRUCK PARTS ***					

Shipping Via		Pkgs		THANK YOU FOR YOUR ORDER		PLEASE NOTE		Merchandise	
FED PRIORITY 1		1		Inspect all packages for damage or missing parts now!		PLEASE PAY BY THIS INVOICE ACCORDING TO THE TERMS ABOVE. Past due invoices subject to 1-1/2% per month service charge.		94.44	
Weight	Charges	Weight	Charges	We must be contacted within 3 days if there is a problem with your order. SEE BACK FOR DETAILS		\$20.00 FEE	FOR RETURNED CHECKS: RETURN POLICY ON BACK	Tax	0.00
								Sub-Total	94.44
								Shipping & Handling	0.00 0
								TOTAL	94.44

TE=85

MillSupply.com

Rec'd By _____



ACI-565559157969

Commercial Invoice

Invoice Number	Purpose of Shipment	Curr	Ult Dest.	Air Waybill Nbr.
		USD	CA	565559157969
Export Dt	C.I. References	Pkgs	Bill T/C	Bill D/T/F
11/26/2013		1	1517-9324-0	1517-9324-0
		OTH		

Shipper:
Ramona Shoby - MILL
Mill Supply Inc
19801 Miles Road

Cleveland
OH 441284117 US (216) 518-5072
ID/EIN:341015622

Consignee:
Bill
Dart Aerospace Ltd
1270 Aberdeen

Hawkesbury
ON K6A1K7 CA (613) 632-3336
ID/EIN:

Broker

Importer
Bill
Dart Aerospace Ltd
1270 Aberdeen

Hawkesbury
ON K6A1K7 CA (613) 632-3336
ID/EIN:

Part Nbr:27526	Marks/Nbrs:	Cntry MFG:US	Net Wgt:	9.00 lbs
HS Code: 8301.20.0000	Unit Qty: 12.00 PCS	Unit Value: 7.870000	Commodity Value:	94.44
Desc: HANDLE				

Total Shipment Weight: 9
These commodities, technology, or software were exported from the
United States in accordance with the Export Administration Regulations.
Diversion contrary to United States law is prohibited.

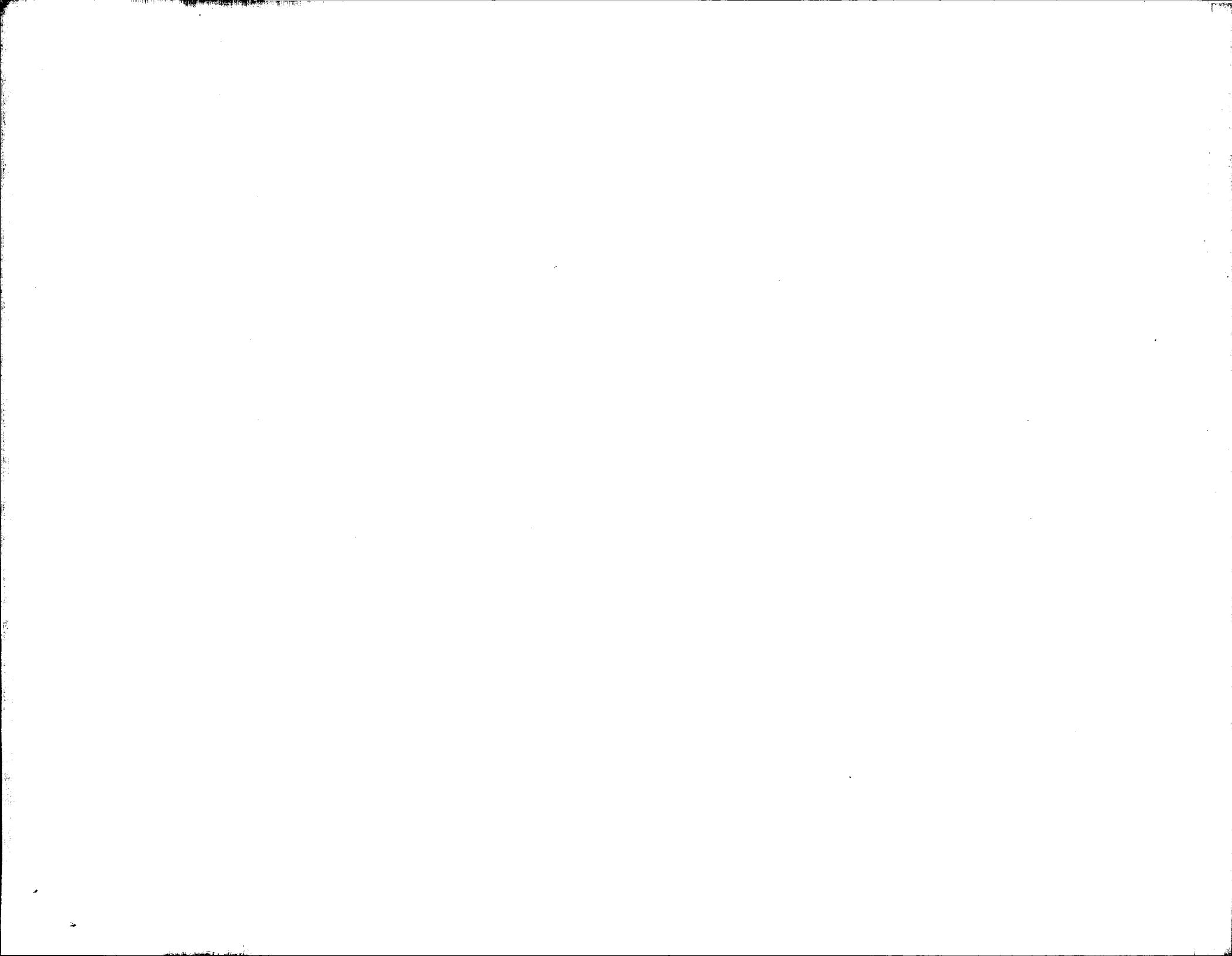
Total Commodity Value:	94.44
Terms of Sale:	FCA/FOB
Freight:	0.00
Insurance:	0.00
Others:	0.00
Total Invoice Value:	94.44

Comments:
1)
2)
3)

I declare all information in this invoice to be true and correct.

Signature of shipper: Ramona Shoby - MILL

11/26/2013





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22191

Purchase Order Date 11/26/2013

PO Print Date 11/26/2013

Page Number 1 of 1

Order From : VU-ROY003
ROYAL BANK VISA
X
HAWKESBURY, ONT X
CAN

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FORWARDED
07/31/11/26

Contact Name		Buyer	Chantal Lavoie
Vendor Phone		Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	COD
Ship To Phone		Currency	USD
Ship Via:	FedEx PI collect	FOB	Destination-Collect
Ship Acct:			

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
				Promised Date			
		Line Comments					
		Delivery Comments					
1	GH180C	Handle	11/29/2013 Yes	12.00 Each		\$7.87	\$94.40
			11/29/2013				

AS PER DWG D3203 REV. C
B109418

Line Total: \$94.4-

PO Total: **\$94.4**

PO Instructions: visa: 4514 0310 0959 2060
exp: 11/17 cid: 134
Linda Lacelle
Mill Supply

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent

Certificate of Conformity or Material Certification required - YES NO